

Date: Monday, 27/04/2009 2:30:07 PM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 47553
 Estimate Number : 12172
 P.O. Number :
 This Issue : 27/04/2009 S.O. No. :
 Prsht Rev. : NC Drawing Number : D2066 REVC
 First Issue : / / Type : SMALL / MED FAB Project Number : N/A
 Previous Run : 34919 Drawing Revision : C
 Material :
 Due Date : 28/04/2009 Qty: *2* Um: Each
 Written By : *W*
 Checked & Approved By : *W*
 Comment : Est. D 02.03.18 Added pick list NG
 est E 07.10.03 removed p/c EC verified by: DD
 Est Rev: F 08-07-24 revC as per dwg (ecr 08-504) DD verified
 by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2052 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Bracket
 batch: *B 39556*

FF 09-04-28

(2)

2.0 D2054 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Bushing - Delrin
 batch: *B 39433*

FF 09-04-28

(2)

3.0 D2055 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Clamp
 batch: *R 34365*

FF 09-04-28

(2)

4.0 D2056 Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Bell Crank Assembly
 batch: *B 39434*

FF 09-04-28

(2)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47553

Part Number: D2066

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M110985

FF 09-04-28

(2)

6.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: M110844

FF 09-04-28

(2)

7.0	MS27039118	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: M1108161

FF 09-04-28

(2)

8.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 2.5053 f(s)/Unit Total : 12.5265 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube

batch: M110968

FF 09-04-28

(2)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube

(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)

Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill 3/16" (0.188") Dia holes per Dwg D2066 using drill jig DT9034

and template DT8054

FF 09-04-28

(2)

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Drawing Name: ARM

Job Number: 47553

Part Number: D2066

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Polish and Deburr

7- assemble parts as per dwg D2066

FF 09-04-28

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/28 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/4/28

(2x)

sq

12.0

QC21

FINAL INSPECTION/W/O RELEASE



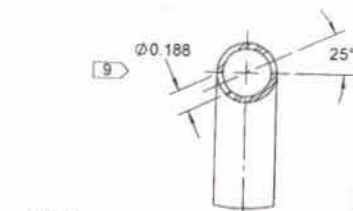
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09/04/28

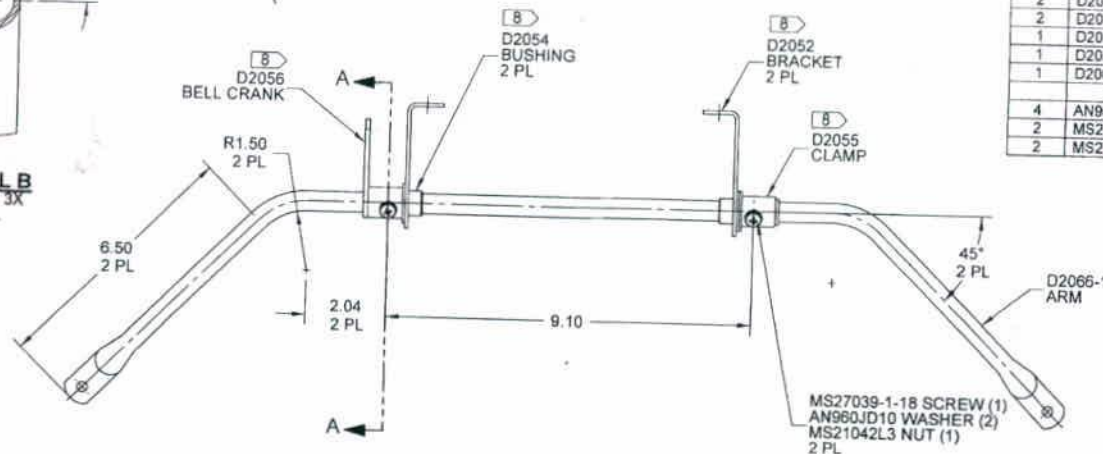
Job Completion



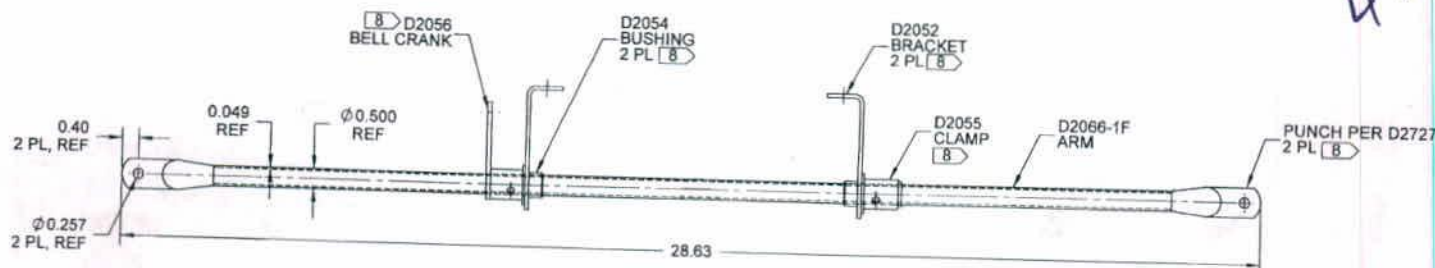
6 09-04-28



SECTION A-A
(SOME PARTS REMOVED FOR CLARITY)



D2066-1 ARM BENDING DETAIL
(MAKE FROM D2066-1F)



D2066-1F ARM CUT LENGTH DETAIL

NOTES:

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL $\phi 0.188$ AFTER BENDING

QTY	P/N	ARM	DESCRIPTION
X	D2066	ARM	
2	D2052	BRACKET	
2	D2054	BUSHING	
1	D2055	CLAMP	
1	D2056	BELL CRANK	
1	D2066-1	ARM	
4	AN980JD10	WASHER	
2	MS21042L3	NUT	
2	MS27039-1-18	SCREW	

RELEASED
08-07-12

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
DRAWN	AW		
CHECKED	AW	DRAWING NO. D2066	SHEET 2 OF 2
MFG. APPR.	AW	TITLE ARM	SCALE NTS
APPROVED	AW	DATE 08.06.12	
DE APPR.	AW		

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8 7 6 5 4 3 2 1

D

C

B

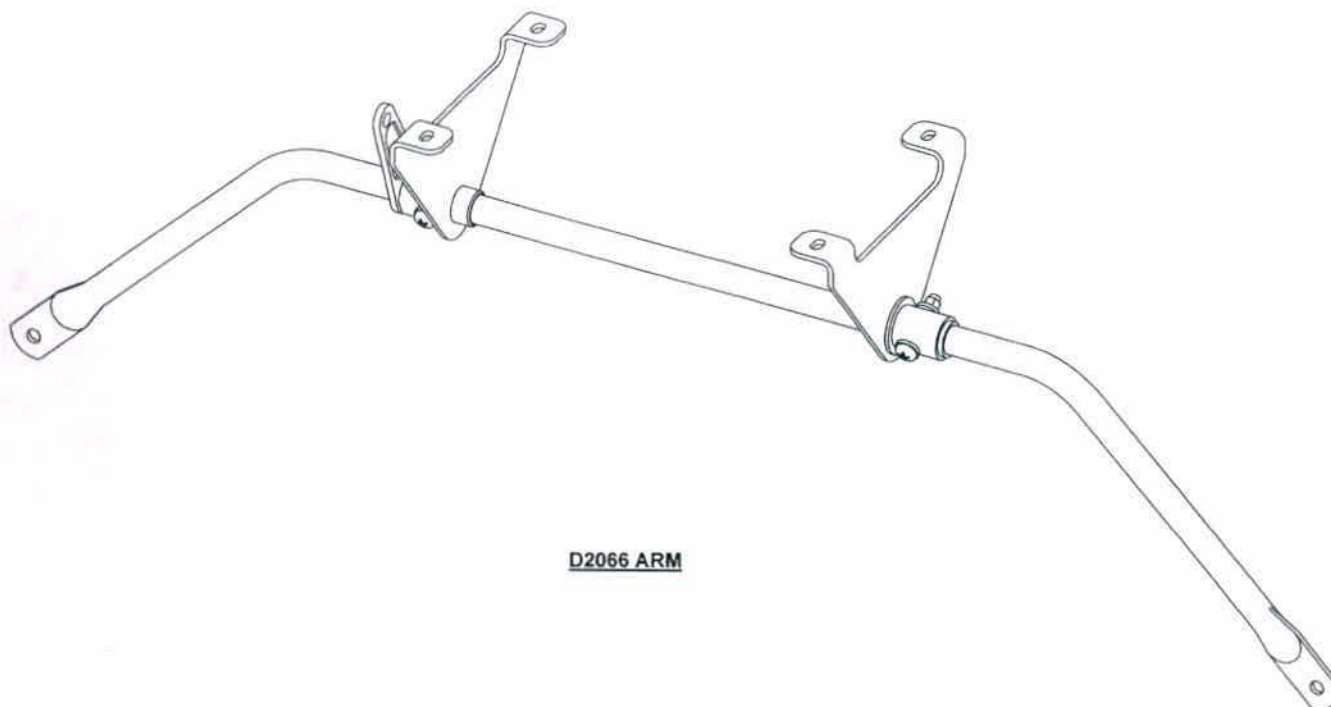
A

D

C

B

A



D2066 ARM

47553

RELEASED
08-07-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2066 REV. C ARM SCALE NTS <small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	
DRAWN	FW		
CHECKED	FW		
MFG. APPR.	FW		
APPROVED	FW		
DE APPR.	FW		
DATE	08.06.12		

8 7 6 5 4 3 2 1

3.0 CARGO MIRROR INSTALLATION

Install the Cargo Mirror as follows:

1. Install D206-558-041/-043 cargo mirror assembly using AN3-4A bolts and AN960JD10L washers. Pickup existing anchor nuts in 4 places.
2. Install D2067 connector onto D2056 bellcrank assembly to locate hole for MS35489-9 grommet. With the mirror in the deployed position, mark and drill $\varnothing 0.125$ " (3.2mm) hole in landing light window panel where the grommet should be located. Open pilot hole to $\varnothing 0.563$ " (14.3mm). Install grommet.
3. Install D2053 bracket using AN526-1032R9 screws. Pickup on existing anchor nuts.
4. Position D2071 cable as shown. Install MS21919DG5 clamps using AN526-1032R9 screws where required. Pickup existing rivnuts or anchor nuts if available.
5. Install D2071 control cable using D2067 connector. Connector should rotate freely in bellcrank when MS21042-3 nut is torqued and cable clamped

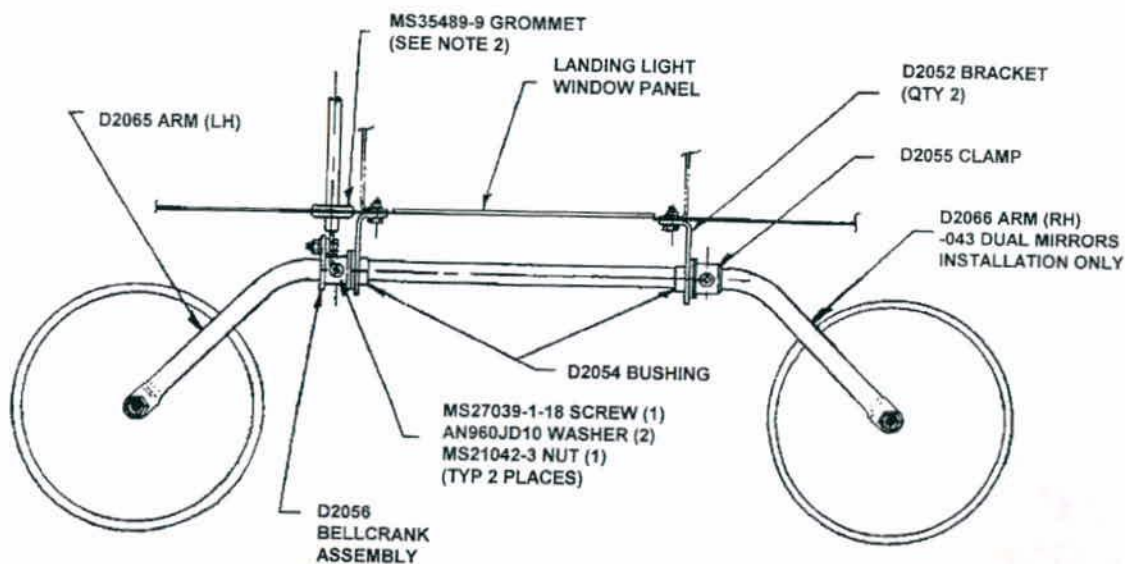


Figure 2: - View A: Looking Aft.
(D206-558-043 Mirror Shown)

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Revision: C

Date: 01.10.03